120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

J3-03-14

-8-84 03

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									DQA:	Date	:
NCR: Yes	/ No			WORK ORDER NON-O	CON	NFORM	MANCE / UPI	DATE	QA Closed:	Date	::
Work Order:		<u> </u>		 DISPOSITION				AGAINST DE			V-12 1
Part No.				Rework Scrap Use-as-is Work Order Update		t Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root Cause	Date	Step	Qty	ption of work order update or Non-conformance		nitial ief Eng	Act Descr	ion iption	Sign & Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved								·			
опаррточеи	<u> </u>	l		 F	AUL	T CATE	GORY				
Landing	-			 General							Pressure/Forced
	Cracks Crushed, Cuffs Heat Tre Inspection Ripples in Torque N	on Strip in	Tube Extrusion	Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish Folio		Instruct Mainte Mislabe Misread Offset Out of t	ion Incomplete ions Incomplete/U enance eled	Jnclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V Power Loss/	ct issing Vrong	Temperature/Cure Weld Wrong Stock Pulled Other

Work Ord February-14-13				*970	1 02*							Page 2	
Item ID: Revision ID:	D3859-041			Accept	*N900	1 040	100)*	Setup	Start Stop	I	S1*	
Item Name: Start Date: Required Date Reference:	Wearplate 2/08/13 : 2/28/13	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item Customer					зюр	*N:	S2*	
Approvals:		an:		Tooling: SPC (Y/N):		Date:			Run	Start Stop	I <i>Z</i> I	R1* R2*	
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accep Qty	t Re Qt	ject y	Reject Number	Insp. Stamp	
130 *130* Large Fab		Large Fab Memo		0.00				4					-0
Large Fab		1-Weld D30 Batch: M1 2059B Hard	2-Weld hard 1 Coat rod Batch: M	859 A/R 316L stainles I facing as per Dwg D385	ss steel rod 9 A/R ****use							•,	- ,
140		QC9- Inspect visual per	QSI004- Fusion Welds	0.00				<u>~</u>		_		6 48	
140 QC Quality Control		Memo		0.00				<u></u>	<u>) </u>	<u>3-03</u>	<u> 56</u>		
150 *150*		QC5- Inspect part comp	leteness to step on W/O	0.00	;			C	∵ \2		3 1	040	

0.00

Memo

Quality Control

_Date: ____

DQA:

NCR:	Yes	/	No

NCR: Y	es	/ No				WORK ORDER NON-	CON	IFORN	MANCE / UPI	DATE	QA Closed:	Date	2:
Mork Ordo	٠					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Work Orde Part N	-					Rework Scrap		ſ	Skid-tube Machining	Crosstube Small Fab	4	Water Jet	Engineering Quality Other
NCR N	lo.					Use-as-is Work Order Update]		noforming Large Fab	Finishing Composite	Rec/Stor	e/Packaging Supplier	Other
Root	ļ					iption of work order update	1	nitial		tion	Sign &		
Cause	_	Date	Step	Qty		or Non-conformance	Chi	ef Eng	Desci	ription	Date	Verification	QC Inspector
oc/Data	\dashv				•								\
quip/Tooling perator		i											
laterial													
etup	ㅓ	:											
ther	\neg												
rocess													
upplier													
raining													
napproved											<u> </u>		
							AUL	T CATE	GORY				
Landi	ng (Gear				General				_	7	-	-
.31		Bending				Bend	Ш	Grain	•	<u> </u>	Ovalized	-	Pressure/Forced
		Centre No	ot Concer	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	F	Temperature/Cure
		Cracks			L	Broken/Damaged		Inspect	ion Incomplete	<u> </u>	Part Incorre	 	Weld
		Crushed/0	Crimped			Burrs	\vdash		ions Incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
		Cuffs				Contamination	-	Mainte		<u> </u>	Part Moved		
		Heat Trea	it			Countersink		Mislabe	eled	_	Positioned V	· · ·	_
		Inspection	n Strip in	Tube		Cut Too Short	-	Misread	t		Power Loss/	Surge	Other
		Ripples in	Bend			Drill Holes		Offset					
-		Torque W	/aves in E	xtrusio	n [Drawing	-		Calibration				
		Turning S	equence			Finish			Sequence				· .
		Wave/Tw	ist in Tub	ре <u> </u>		Folio		Outside	Dimensions				

Work Order ID 9 February-14-13 12:57:52			*970	೧ 2*						Page 3
Item ID: D3859-04 Revision ID: Item Name: Wearplate	1		Accept	*N900040	110 0)*	Setup	Start Stop	*N *N	S1* S2*
Start Date: 2/08/13 Required Date: 2/28/13 Reference:	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item ID: Customer:						·
Approvals: Process I	Plan:	Date:		Date:			Run	Start Stop	*N *N	R1* R2*
Sequence ID/ Work Center ID 160 *160* Powdercoat Powder Coating A (2 2 6 6	Operation Description Grey Sandtex(Ref:4.3.5.6 Memo START TIMI 3 7 7 7	E: $7 = 3$ FINISH TIME:	Set Up/ Run Hours 0.00 0.00 OVEN TEMPERATURE: 0.00	Tool ID Tool	# Plan Code	Accept Qty	Qtj	v 1 M-f	Reject Number	Insp. Stamp 3/03/2
170 QC Quality Control 180 *180* Packaging	Memo Identify as per dwg & Sto Memo	ock Location: (= =====	0.00			*		-	Jel	(3/0) /21
Packaging		ST	500		Yx	Sa	,	13.	-3-	78 -

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WORK ORDER NON-CONFORMANCE / UPDATE NCR: Yes / No QA Closed: Date: **AGAINST DEPARTMENT/PROCESS DISPOSITION** Work Order: Engineering Crosstube Water Jet Skid-tube Rework Quality Small Fab Prod. Eng. Coor. Machining Part No. Scrap Thermoforming Finishing Rec/Store/Packaging Other Use-as-is Supplier Composite Work Order Update Large Fab NCR No. Sign & Action Description of work order update Initial Root Description Date Verification QC Inspector Chief Eng Qty or Non-conformance Date Step Cause Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved **FAULT CATEGORY Landing Gear** General Pressure/Forced Ovalized Bend Grain Bending Temperature/Cure Over/Under tolerance BOM/Route Hardware Centre Not Concentric to O/S Weld Broken/Damaged Part Incorrect Inspection Incomplete Cracks Wrong Stock Pulled Instructions Incomplete/Unclear Part Lost/Missing Crushed/Crimped Burrs Maintenance Part Moved Cuffs Contamination Positioned Wrong Countersink Mislabeled Heat Treat Other Power Loss/Surge Misread Inspection Strip in Tube **Cut Too Short Drill Holes** Offset Ripples in Bend Out of Calibration Drawing Torque Waves in Extrusion

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish

Folio

Work Orde February-14-13				*970) 02*						Page 4	
Item ID: Revision ID: Item Name:	D3859-041 Wearplate			Accept	*N900	040	100)* s	Setup	Start Stop	*NS1* *NS2*	
Start Date: Required Date: Reference:	2/08/13 2/28/13	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item II Customer:	D:						
Approvals:	Process Pla	an:	Date:	Tooling: SPC (Y/N):		nte:		F	Run	Start Stop	*NR1* *NR2*	
Sequence ID/ Work Center I 190 *100* QC Quality Control	D	Operation Description QC21- Final Inspection - Memo	Work Order Release	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Rej. Qty	12	Reject Insp. Number Stamp 13 3 3 7 7 1	F. 8

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NCR: Y	es/	/ No			WORK ORDER NON-C	O	NFORM	MANCE / UPI	DATE	QA Closed:	Date	:
Work Orde	er:				DISPOSITION Rework	1		Skid-tube	AGAINST DE	PARTMENT,	PROCESS Water Jet	Engineering
Part N	•				 Scrap Use-as-is Work Order Update		Thern	Machining noforming Large Fab	Small Fab Finishing Composite	-	d. Eng. Coor. re/Packaging Supplier	Quality Other
Root Cause		Date	Step	Qty	ption of work order update or Non-conformance		nitial ief Eng		tion ription	Sign & Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved												
					 	AUL	T CATE	GORY				
Landi	_	Bending Centre No Cracks Crushed/ Cuffs Heat Trea Inspectio Ripples in	Crimped at n Strip in ı Bend	Tube	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing		Instruct Mainte Mislabe Misread Offset	ion Incomplete cions Incomplete/ enance eled	Unclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct ssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
		Turning S			Finish		Out of 9	Sequence				

Outside Dimensions

DQA:

Date:

Wave/Twist in Tube

Folio

Picklist Print

February-14-13 10:44:39 AM

Work Order ID:

97002

Parent Item:

D3859-041

Parent Item Name:

Wearplate

Start Date: 2/08/13

Required Date: 2/28/13

Page 1

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP Rev:A 09-02-03 new issue DD verified by:EC

Comments:	IPP Rev:A 09-02-	os new issue DD	vermed	by:EC										
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status	
M304S16GA		Purchased	No			100	sf	589.7560	0.85	3.4	3.5		Jm13-3	
304/316 Sheet .063											2,3		<u> </u>	5-17
				Location		Loc Qty	<u>Lo</u>	oc Code						
1				MAT020		589.756								
1				122	245	5.156								
-				123	136	140.9								
I				124	428	123.7			194	1438				
				124	572	320							٠.,	
D3009 ₋ 3		Manufactured	No			130	Each	162.0000	6	24				214
Cup													<u> 13-03-</u>	25
				Location		Loc Oty	<u>La</u>	oc Code					Jes.	Z
ı				WA001		162								
,				790	078	30							·	
				883	886	3								
				93	96	129			1.3	<u>48 1</u>				
					· · · · · · · · · · · · · · · · · · ·									

WORK ORDER NON-CONFORMANCE / UPDATE NCR: Yes / No QA Closed: Date: **AGAINST DEPARTMENT/PROCESS** DISPOSITION Work Order: Crosstube Water Jet Engineering Skid-tube Rework Prod. Eng. Coor. Quality Machining Small Fab Part No. Scrap Other Rec/Store/Packaging Thermoforming Finishing Use-as-is Supplier Work Order Update Large Fab Composite NCR No. Description of work order update Action Sign & Initial Root Chief Eng Description Date Verification QC Inspector or Non-conformance Date Step Qty Cause Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved **FAULT CATEGORY Landing Gear** General Ovalized Pressure/Forced Bend Bending Grain Over/Under tolerance Temperature/Cure BOM/Route Hardware Centre Not Concentric to O/S Part Incorrect Weld Broken/Damaged Inspection Incomplete Cracks Wrong Stock Pulled Instructions Incomplete/Unclear Part Lost/Missing Crushed/Crimped Burrs Part Moved Cuffs Contamination Maintenance **Positioned Wrong** Countersink Mislabeled Heat Treat Other Power Loss/Surge Misread **Cut Too Short** Inspection Strip in Tube **Drill Holes** Offset Ripples in Bend Out of Calibration Drawing Torque Waves in Extrusion Finish Out of Sequence Turning Sequence

Outside Dimensions

DQA:

Date:

Wave/Twist in Tube

Folio

DART AEROSPACE LTD	Work Order:	97002
Description: Wearplate	Part Number:	D3859-1
Inspection Dwg: D3859 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.879	+0.010/-0.001	0.879"	-		V	JAMOI
0.75	+/-0.030	0.753"			V	
4.250	+/-0.010	4. 246"	•		V	
3.00	+/-0.030	3.009"	-		V	
5.75	+/-0.030	5.748"	-		V	
9.000	+/-0.010	9.007"	-		Ŭ	Productor
1.50	+/-0.030	1.50"	1-c		V	
20.40	+/-0.030	20.40"	-		T	Productions
0.063	+/-0.010	0.060"	-		V	
				"		
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L	<u> </u>		DAQ-			

Measured by:	Jon	Audited by:)9	Prototype Approval:	N/A
Date:	F1-8-81	Date:	13-03-1-3	Date:	N/A

Rev	Date	Change		Revis	ed by∧	Approved
Α	09.05.20	New Issue	P/O D3859-041	KJ	2	77
						



